

Work Order ID 74945-1

October 13, 2011 1:06:57 PM

\*74945\*

Page 1

Item ID: D412-698-012

Revision ID:

Item Name: Cabin Door Roller, RH

Start Date: 10/13/11

Required Date: 10/21/11

Reference:

Start Qty: 2.00

Req'd Qty: 2.00

\*2\*

\*2\*

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan: M.C. J

Date: 11/10/13 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

0.00

0.00

8/26/13

CK per M.C. J 11/10/13

110

\*110\*

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

11/10/13

120

\*120\*

QC

Quality Control

QC4- 100% inspect kits for completeness

Memo

0.00

0.00

8/26/13

(X)

# Work Order ID 74945

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Page 2

Item ID: D412-698-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Cabin Door Roller, RH

Stop **\*NS2\***

Start Date: 10/13/11 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 10/21/11 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

**\*130\***

Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPP D412-698-012

Location: 62

*Revo*

*21/1/38*

*(2)*

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*CK 12/01/13*

*MF 12-01-13*



# Picklist Print

October 13, 2011 1:07:02 PM

Work Order ID: 74945

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

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\*D412-698-012\*

Page 2

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

24.0000

9

18

\*\*

14X B75035 SP 11/11/11

\*D3199-1\*

Bracket

Location

Loc Qty

Loc Code

ST236A

24

61484

2

73363

22

Manufactured No

110

Each

29.0000

1

2

\*\*

11/10/11 SP (20)

D3202-1

\*D3202-1\*

Cover

Location

Loc Qty

Loc Code

ST241A

29

68240

1

70294

28

2



**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01

# Picklist Print

Monday, June 13, 2011 2:26:37 PM

Page 1

Work Order ID: 70716

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: C04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS  
IPP Rev: D 08-01-28 change to rev D ECN 1104 DD

REFERENCE ONLY

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-141

Manufactured No

100

Each

6.0000

3

6



369924

11/6/11

Bracket Assembly

Location

Loc Qty

Loc Code

ST235A

6

68242

6

D3121-143

Manufactured No

110

Each

7.0000

1

2



5

Bracket Assembly

Location

Loc Qty

Loc Code

ST235A

7

61406

1

68265

6

D3183-043

Manufactured No

110

Each

2.0000

1

2



370299

11/1/11

Bracket Assembly

Location

Loc Qty

Loc Code

ST236

2

66829

2

D3137-043

Manufactured No

110

Each

5.0000

1

2



5

11-09-01

Bracket Assembly

Location

Loc Qty

Loc Code

ST235B

5

69047

5

B70979

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries